



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2144

Job Sheet 202906



Part No: D2144

Job Qty: 20 pcs

Part Name: Hinge Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP: D 04.05.06 Reformat KJ/RF IPP Rev:E Now on Waterjet 06-10-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		12/18/19	0.00	1.11	Waterjet - Flow		JRB 11/14/19
110	QC 2	20 pcs		12/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S231702



Part: D2144

Job No: 202906

Serial No/Batch: S231702

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/14/19

Plex 11/5/19 10:43 AM Dart.lajeunesse.marie

120	QC 8	20 pcs	12/18/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Small Fab - 2 - B4B	20 pcs	12/18/19	0.00 0.77	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
140	Small Fab - Brake NC - B4B	20 pcs	12/18/19	0.01 1.35	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
150	QC 5	20 pcs	12/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	

DAS
40
9-89

NOV 20 2019

DAS
30
9-89

DEC 23 2019

					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JAN 02 2020
					QC 5 - 61	9-89
					QC 5 - 81	
160	Large Fab - Welded Assy-2-B4B	20 pcs	12/18/19	0.00 3.60	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	MV Jan 13/20
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
170	QC 9	20 pcs	12/18/19	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	CL
					QC 9 - 9	
180	QC 5	20 pcs	12/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	CL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190	Powdercoat - 1 White Gl(A)-B4B	20 pcs	12/18/19	0.00 0.36	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-01-21.
					Powdercoat - 4 - B4B	
200	QC 3	20 pcs	12/18/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	

					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	JAN 2 1 2020 ^{Dr} 40 ₉₋₈₉
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	20 pcs	12/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS 28 ₉₋₈₉
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220	QC 21 - SA	20 pcs	12/18/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg D2144

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - Deburr if necessary

140 - (Bend/Assemble as per dwg) Form as per Dwg D2144 Rev: D

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Weld per dwg A/R S.S. rod Batch: M138974) 1- Weld corner as per Dwg D2144 & QSI 004 2- Grind flush

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____

200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.8900 sf (.0945 ea)	100-Waterjet - Flow - 1	5207058

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	275	0

Part Specifications

Specifications could not be found.

Plex 11/5/19 10:43 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	202906
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.386	✓		JRB-02V	
3.022	+/-0.010	3.021	✓		Square	
2.468	+/-0.010	2.463	✓			
1.913	+/-0.010	1.915	✓			
1.555	+/-0.010	1.556	✓			
4.126	+/-0.010	4.128	✓			
3.465	+/-0.010	3.468	✓			
0.340	+/-0.010	.343	✓			
0.625	+/-0.010	0.626	✓			
1.000	+/-0.010	0.999	✓			
1.083	+/-0.010	1.087	✓			
1.660	+/-0.010	1.661	✓			
2.312	+/-0.010	2.316	✓			
2.844	+/-0.010	2.844	✓			
3.294	+/-0.010	3.292	✓			
Ø0.257	+0.006/-0.001	0.259	✓			
Ø0.171	+0.005/-0.001	0.174	✓			
Ø0.320	+0.006/-0.001	0.322	✓			
0.354	+/-0.010	0.352	✓			
0.063	+/-0.010	0.060	✓			

Measured by: JRB 11/14/19	Audited by: DAS 40 11/20/19	Prototype Approval:	N/A
Date: 11/14/19	Date: 11/20/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					